Dart Aerospace Ltd. Tuesday, 08/07/2008 1:46:55 PM User: Linda Lacelle **Process Sheet** : FORWARD GUIDE PLATE : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 40373 : 13365 **Estimate Number** P.O. Number **Part Number** : D35899 : 08/07/2008 S.O. No. : : D3589 REV B PRELIM 08.07.14 **Drawing Number** This Issue Prsht Rev. : NC **Project Number** : N/A : // : SMALL /MED FAB : B PRELIM First Issue Type **Drawing Revision** : 05028 **Previous Run** Material Each **Due Date** : 15/07/2008 Qty: 1 Um: Written By Checked & Approved By Comment : Est Rev:A 08-06-05 new issue DD verified by:ec **Additional Product** PRELIMINARY ISSUE Job Number: Seq. #: **Machine Or Operation:** Description: M304S16GA 304/316 .063 Sheet Comment: Qty.: 0.0698 sf(s)0.0698 sf(s)/Unit Total: 304/316 .063 Sheet batch: 10 2 09 WATER JET 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D3589 Dwg Rev: B prelim
Prog Rev: B prelim M 08 07 09 2-Deburr if necessary 8-7-14 INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0 QC8 SECOND CHECK Comment: SECOND CHECK 08,072 5.0 PACKAGING : PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock USED ON D3589-041 BJN: BA0366 12,000 21

Page 1

Location:

Dart Aerospace Ltd

W /O:		WORK ORDER CH	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No: <u>D3589-9</u>	PAR #: <u> </u>	Fault Category:	En Design	··· NCR	No E	QA:	Date: _<	oskoalig
					QA: N/C Clo	sed:	Date:	

NCR: 4	0373	W	ORK ORI	DER NON-CONFORMAN	CE (NCR)			
		Corrective Action Section B			Verification	Approval	Approval	
DATE	DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
JB .08 M	5.0	PART WAS NOT ALIGNING PROPERLY UPON WELDING. MARK PART, RENERSE EUG. + MAKE NEW PART RAYED ON ROVISED TIME.	08.06.04	SCAAP MAKE NEW PORT DER NEW NWG.	05.00.00	59/08/06	00. 20°s	ælælæ
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NOTE: Date & initial all entries

Date: Tuesday, 08/07/2008 1:46:55 PM **User:**

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FORWARD GUIDE PLATE

Job Number: 40373

Part Number: D35899

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



û 08.07.21

EFFECTIVE OB OF STATE OF STATE

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES							
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Part No) :	PAR #:	Fault Category:	NCR: Yes	No DQ	A:	_ Date: _			

QA: N/C Closed: ____ Date: ____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC	Description of NC Corrective Action Section B		Verification	Approval	Annaval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
								3.		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40373
Description: Forward Guid Plate	Part Number:	03589-9
Inspection Dwg: D3589 Rev: B preliminary		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.16	+1-0.030	5.143	/		vern	
1.29	+1-0.030	1.289	J		GNLV	
1.86	+1-0.030	1.863	1		HG	
R0.25	+1-0.010	RO.25	J		RG HG	
0.97	+1-0.030	0.97	J		HG.	
					 	

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Measured by:	M M	Audited by:	A L	Prototype Approval:	a
Date:	08 07 09	Date:	08/57/08	Date:	1/4

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	

DART AEROS	SPACE LTD	Work Order:	40373
Description:	FORWARD GUIDE PL	ATC Part Number:	D3589-9
Inspection Dwg	: 1)3589-9 Rev: B ORElim		Page 1 of 1

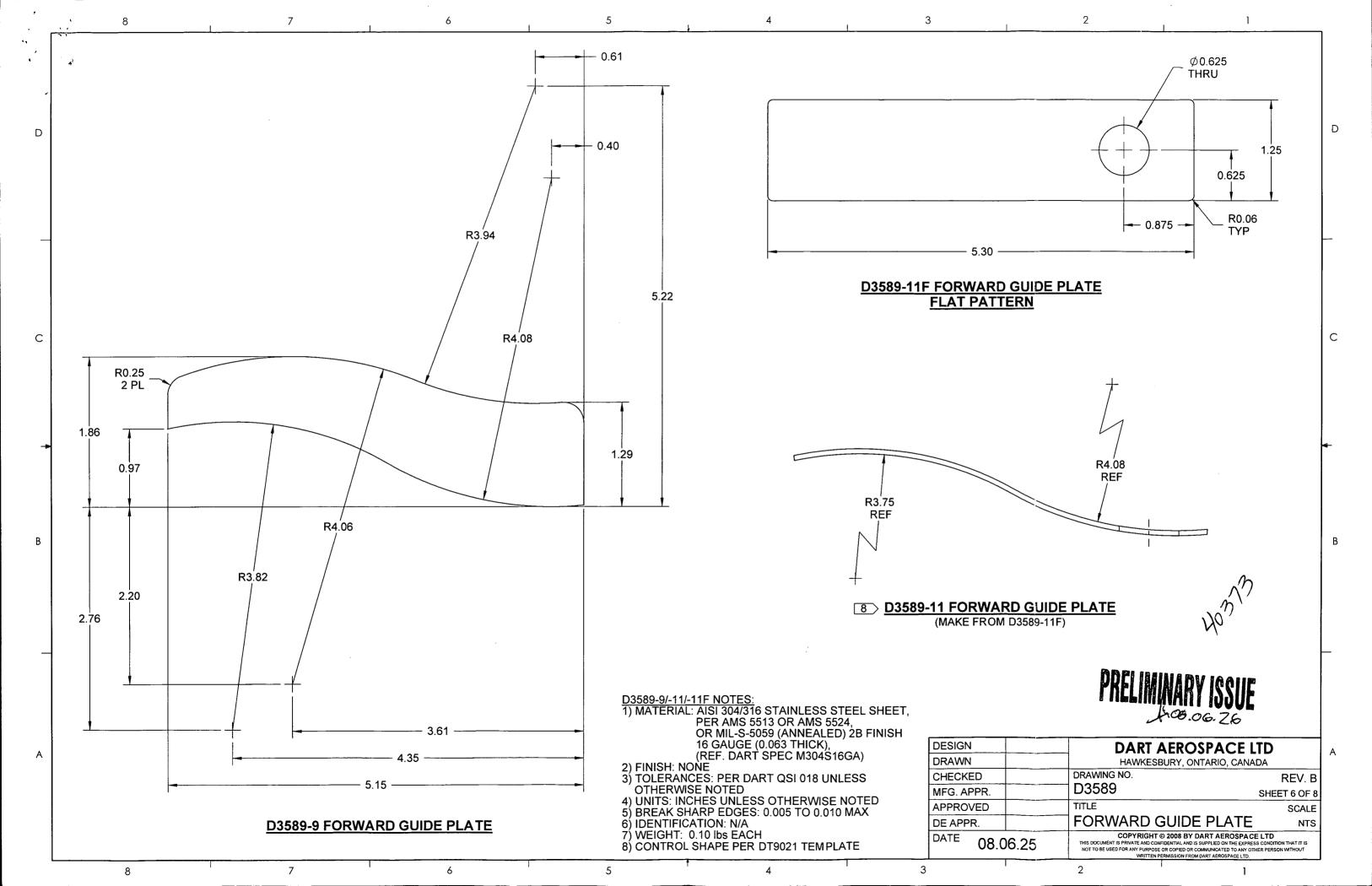
FIRST ARTICLE INSPECTION CHECKLIST

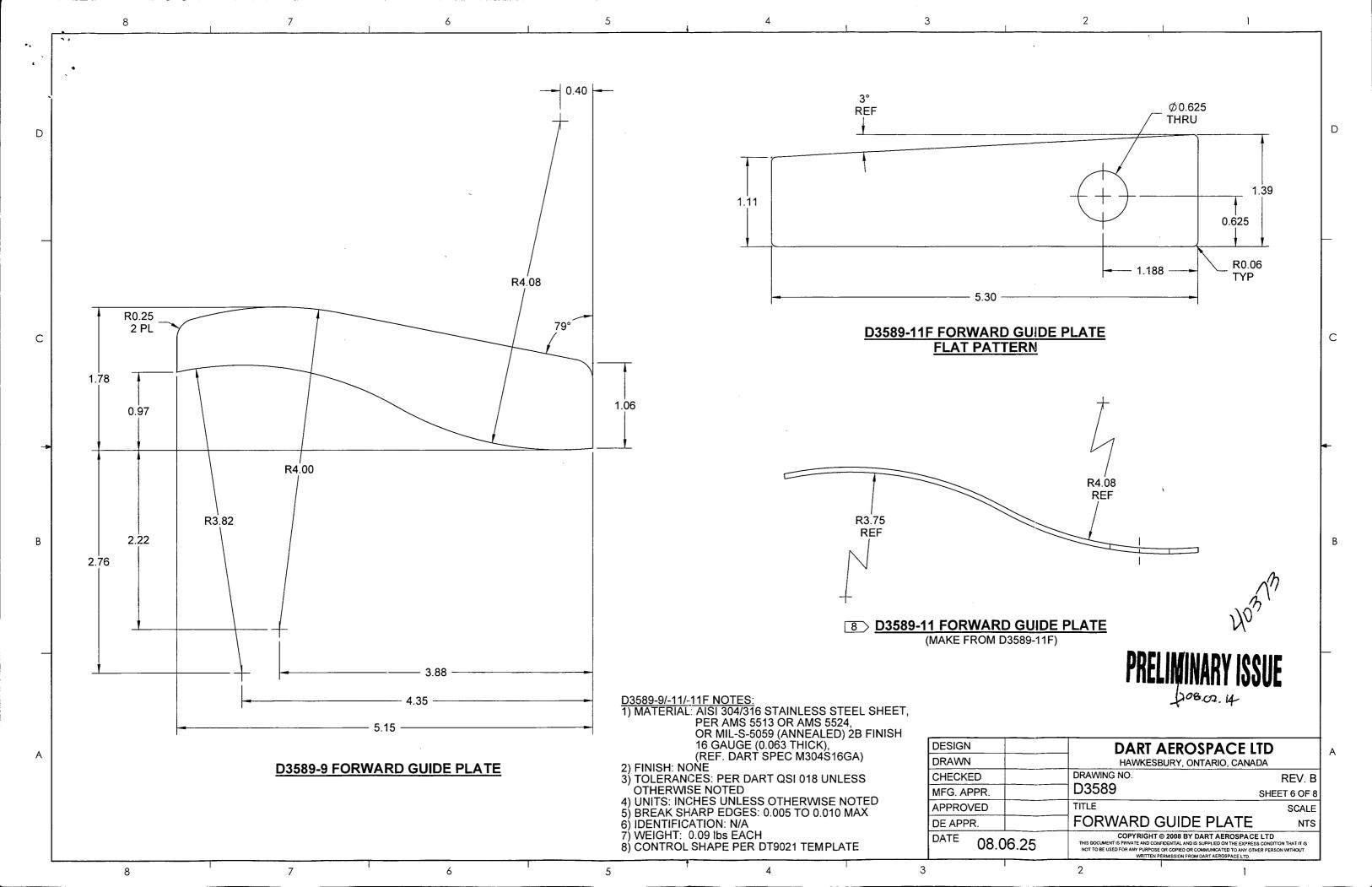
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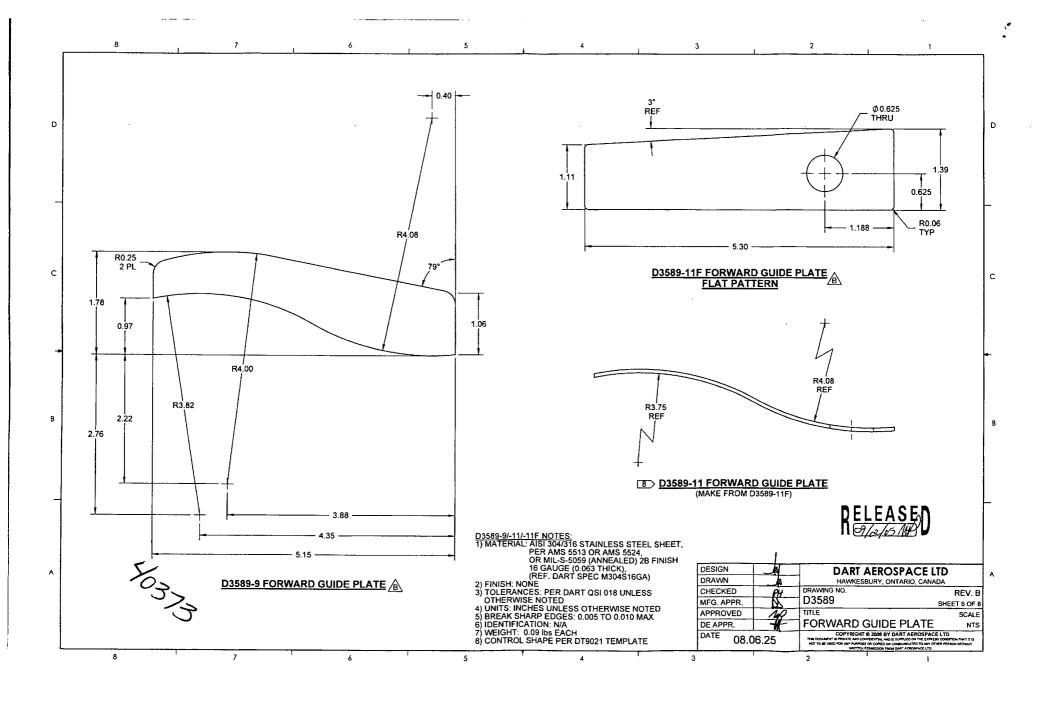
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Α		New Issue	KJ/JLM	







Tuesday, 08/07/2008 1:46:55 PM Linda Lacelle User **Process Sheet** : FORWARD GUIDE PLATE **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer : 40373 Job Number **Estimate Number** : 13365 : D35899 **Part Number** P.O. Number : D3589 REV B PRELIM : 08/07/2008 S.O. No. : **Drawing Number** This Issue Project Number : NC Prsht Rev. : B PRELIM : // : SMALL /MED FAB **Drawing Revision** Type First Issue : 05028 Material **Previous Run** Each Qty: 1 Um: : 15/07/2008 **Due Date** Written By Checked & Approved By new issue DD verified by:ec : Est Rev:A 08-06-05 Comment **Additional Product** PRELIMINARY ISSUE Job Number: Description: **Machine Or Operation:** Seq. #: 304/316 .063 Sheet M304S16GA 1.0 Comment: Qty.: 0.0698 sf(s)/Unit Total: 304/316 .063 Sheet batch: 10 2 09 0 Comment: FLOW WATER JET 1-Cut as per Dwg D3589 Dwg Rev: B ocelin Prog Rev: Bycaling 2-Deburr if necessary 8-7-15 INSPECT PARTS AS THEY COME OFF MACHINE 3.0 10 80 PARTS AS THEY COME OFF MACHINE Comment: INSPECT SECOND CHECK 4.0 QC8 08,072 Comment: SECOND CHECK PACKAGING RESOURCE #1 PACKAGING 1 5.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

Dart Aerospace Ltd

Dart Aerospace Ltd 1270 Aberdeen St Hawksbury, Ontario K6A 1K7 Phone: (613) 632-3336

Fax:

(613) 632-4443

Receiving Slip

Date Page May 22, 2008

Receipt Number RCP00007949

REFERENCE ONLY TO:

Purchase From:

Campi Steel 935 Boul. Du Havre Valleyfield, QC J6S 5L1

Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St Hawksbury, Ontario K6A 1K7

Reference		Description	Cont	act	Vendor Number VC-CAM002	PO Number PO00006375]
Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost Extend		٦

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Da	
	M1010B0750X025	ASTM A21 Steel .75"x	40.0000	f	6.250000		May 22, 200	
		OR CSA G40-21, 38V	1/44W/50W/60	W/70W	1		Vidy 22, 200	
		MATERIAL: AISI 10	10-1025 OR A	STM		1		
		A36/A366/A569/A570		7			Í	
		B/N108090	ł			1		
	M2024T3R1250	2024-T3 Round Bar 1.2	12.0000	f	10.950000	131 40	May 20, 200	
		PER AMS-QQ-A-200/	BOR AMS 41	50/4164/4		131.40	May 22, 200	
		MATERIAL: 2024-T3	OR T3510/T2	P2/4104/4. 511 ATTR	(0)			
		ROUND BATR	OK 15510/15	311 ALUN	IINUM			
	1	B/N108090						
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		PER QQ-A-250/4 OR	1		8.750000	840.00	May 22, 200	
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REFEDENCE		B/N108090	ALOMINUMISHEET					
ENENCE		2024-T3 .063 sheet	96.0000	sf	14.150000	1,358.40		
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		PER AMS-QQ-A-200/8	OR AMS 4160)	ĺ	ľ		
		PER AMS-QQ-A-225/8	OR AMS 4117	7/4128/411	5/4116 OR			
		SCOURT LORING 1	1		1			
		MATERIAL: 6061-T6	OR 6061-R6 5 1/	T6510/T6	511/T62	1	j	
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